

Date: Wednesday, 6/6/2007 1:41:57 PM  
 User: Kim Johnston

## Process Sheet

24

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DART 13-MAN 3-POINT SHOULDER HARNESS KIT
Job Number : 32759	
Estimate Number : 12865	
P.O. Number : <u>N/A</u>	Part Number : D412702041B
This Issue : 6/6/2007 S.O. No. : <u>N/A</u>	Drawing Number : D412702041B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 32419	Material : <u>N/A</u>
Written By : _____	Due Date : 6/15/2007 Qty: 2 Um: Each
Checked & Approved By : <u>[Signature] 07.06.07</u>	
Comment : est rev A 07.05.10 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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②

Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D412-702-041B CHG001 002 KT 07.06.08

2.0	D412702059	GROMMET KIT
-----	------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET KIT

batch: B32327 ✓

3.0	D412702101B	HARNESS ASSEMBLY
-----	-------------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32790 ✓

4.0	D412702103B	HARNESS ASSEMBLY
-----	-------------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32809 ✓

5.0	D412702105B	HARNESS ASSEMBLY
-----	-------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32608 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 6/6/2007 1:41:57 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D412702107B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32791

7.0

D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32488 (1x) ✓ B32811 ✓

8.0

D412702111B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32489 ✓

9.0

D412702113B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32490 ✓ ✓

10.0

D412702115B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32491 (1x) ✓ B32339 (1x) ✓

11.0

D412702117B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32340 (1x) ✓ B32492 (1x) ✓

12.0

D35421

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET

batch: B32606 ✓ ✓

EJ 6/6/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:41:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D35711

GUIDE



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

GUIDE

batch: B31868 ✓

14.0

D35713

GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GUIDE

batch: B31869 ✓

15.0

D3572041

GUIDE ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GUIDE ASSEMBLY

batch: B31870 ✓

16.0

D3578041

DOUBLER



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

DOUBLER

batch: B32483 (19x) B31866 (4x) B32831 3x

17.0

D3610041

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: B32607 2x ✓ B32240 (2x) ✓

18.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

CAP

batch: B32426 ✓

19.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: M101291 ✓

*[Handwritten signature]* (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN416A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: M118949 ✓

21.0

AN425A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: M1104438 ✓

22.0

AN44A

Eyebolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Eyebolt

batch: M1101291 ✓

SUBSTITUTE AN4-44A BOLT  
PER IIN-D412-702

LE 07.06-20

M1101291

23.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M1104214 ✓

24.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

SCREW

batch: M1104407 ✓

25.0

MS24694S58

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 20.0000 Each(s)

Screw

batch: M11735 ✓

26.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M1104407 ✓

*Eff 07/06/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/04/00  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer

batch: M103691 ✓

28.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M103962 ✓

1 more/bag

29.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

batch: M102552 ✓

30.0

CR321244

Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Cherry Rivet

batch: M116896 ✓

CP 7/6/14 (2)

31.0

QC3

INSPECT WORK TO CURRENT STEP



CL 7/6/20 (2)

Comment: INSPECT WORK TO CURRENT STEP

CL 7/6/20 (2)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG001

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

D

CL 7/6/20

(2)

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CL 7/6/20

Job Completion



CL 7/6/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1*	1*			1*	D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL

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WORK ORDER  
NO. 32759

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Revision: D

Date: 07.04.12

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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WITHOUT NOTICE  
WORK ORDER  
NO. 32759

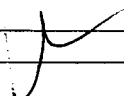
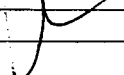
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Revision: D

Date: 07.04.12

Date: Thursday, 15/11/2007 6:55:16 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-702-UPDATE PAPERWORK
Job Number	: 35746		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 15/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: ECN 1065
First Issue	: N/A	Project Number	: N/A
Previous Run	: 00015	Drawing Revision	: N/A
	Type	Material	: N/A
	: SMALL /MED FAB	Due Date	: 22/11/2007
Written By	: 	Qty:	1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 REMOVE FROM STOCK:

D412-702-021 31206 2X 30645 2X

D412-702-023 35411 3X

D412-702-025 32001 3X - 31174 3X

D412-702-031 33277 1X

D412-702-033 31453 1X

D412-702-041A

D412-702-041B 34427 1X - 32759 1X

D412-702-043A 34218 1X

D412-702-043B 32756 1X

D412-702-045A 34213 1X

D412-702-045B 32757 1X

D412-702-059 32327 1X

D412-702-069 34435 7X

ADD NEW PAPERWORK TO KITS IN STOCK  
 EASA STC EASA.IM.R.S.00710 REV.1

RETURN KITS TO STOCK

## CUSTOMER RETURN

H:\FORMS\Quality Assurance\approved QA\CR revl